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(54) MANUFACTURE OF FIBER REINFORCED PLASTIC HONEYCOMB CORE

(57)Abstract:

PURPOSE: To improve simply bonding strength by providing bonding materials in the state of stripes before fiber reinforced plastic prepreg sheets are cured, also providing separators on the intervals formed among the bonding materials, and then laminating and heating the prepreg sheets, developing them in the laminating direction, and then removing the separators and heating again.

CONSTITUTION: Bonding materials 4 are provided in the state of stripes in parallel before fiber reinforced plastic prepreg sheets 7 are cured perfectly, and separators 8 are provided on the intervals forming sections not to be bonded. The bonding materials 4 and the separators 8 are laminated by shifting their positions by half-pitch successively before the prepreg sheets are cured perfectly, and then heating them to bond respective bonding materials and separators one another by the bonding material 4. Then the bonding materials 4 are melt cured by heating and pressurizing to bond the prepreg sheets 7. Then tensile force is applied in the upper and lower direction to stretch and fold the prepreg sheets, and the separators 8 are released, and then the prepreg sheets 7 are heated at the curing temperature of the sheets, stretched and folded, and cell walls 18 are formed by the perfectly cured prepreg sheets 7 to form a honeycomb core.

Then tensile force is applied in the upper and lower direction to stretch and fold the prepreg sheets, and the separators 8 are released, and then the prepreg sheets 7 are heated at the curing temperature of the sheets, stretched and folded, and cell walls 18 are formed by the perfectly cured prepreg sheets 7 to form a honeycomb core.

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